

(UPS)

*Rush Ship March 6

Work Order ID 130332

130332

Page 1

Thursday, March 05, 2015 4:20:37 PM

Item ID: 647.1305 Accept *N900040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: EC145 Cable Cutter System Removable Provisions U Channel Compatible
Start Date: 3/05/15 Start Qty: 1.00 *1* Cust Item ID:
Required Date: 3/06/15 Req'd Qty: 1.00 *1* Customer:
Reference:

Approvals: Process Plan: [Signature] Date: 3-2-5 Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
647.1300	C (ECN2)								
100	Document Control	0.00 27							
100	DOCUMENT CONTROL	9-89							
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile & type labels per PPP 647.1305								
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120	QC4=100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.00							
Quality Control									

MCS 15-03-06

(1x)

DAS
46
9-89

MAR 06 2015

DAS
27
9-89

MAR 06 2015

DAS
27
9-89

(1x)

DAS
46
9-89

MAR 06 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
		☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge
		☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other

Work Order ID 130332

130332

Page 2

Thursday, March 05, 2015 4:20:37 PM

Item ID: 647.1305 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: EC145 Cable Cutter System Removable Provisions U Channel Compatible
 Start Date: 3/05/15 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 3/06/15 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

130

Packaging

Packaging

Packaging

Memo

Identify and pack for shipping as per PPP 647.1305

Location: _____

EXPIRY DATE OF:

RTV Loctite 598: _____

MAGNOBOND 6398 PART 1: _____

MAGNOBOND 6398 PART 2: _____

SEALANT PR-1425: _____

***INDICATE ON BOX EXPIRY DATE OF RTV, MAGNOBOND PART1,
MAGNOBOND PART2 AND SEALANT PR-1425 ***

DAS
06
8-89

MAR 06 2015

NOT IN KIT. MF 15-3-6

140

140

QC

Quality Control

QC21- Final Inspection - Work Order Release

Memo

*** Enter exp. date in lot maintenance for RTV loctite 598, MAGNOBOND
PART1, MAGNOBOND PART2 AND SEALANT PR-1425***

NOT IN KIT. MF 15-3-6

MLJ 15-03-06

MF 15-3-6

A.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
		☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge
		☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other

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130332

647 1305

Required Date: 3/06/15

Required Qty: 1.00

Comments: IPP REV:A NEW ISSUE 13.07.16 JLM VERIFIED BY:DD IPP
REV:B 14.07.31 AS PER ECN C2 DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
647.0112 *647-0112* Strut Bracket	DAS 46 9-89	Manufactured	No				Each	227.0000		83			
									**			DAS 27 MAR-06 2015	DAS 06 9-89
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				CCK109				227					
				112215				52					
				122245				31		8			
				122871				52					
				M130388				92					
647.1402 *647-1402* Lower Cutter Assembly	DAS 46 9-89	Manufactured	No				Each	3.0000		1			
									**			DAS 27 MAR-06 2015	DAS 06 9-89
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				CCK048				3					
				1123319				3		1			
647.2011 *647-2011* Lower Strut	DAS 46 9-89	Manufactured	No				Each	31.0000		12			
									**			DAS 27 MAR-06 2015	DAS 06 9-89
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				Cck021				31					
				123511				8		2			
				125082				15					
				91803				4					
				92560				4					

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
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Picklist Print

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Page 2

Work Order ID: 130332

130332

Parent Item: 647.1305

647 1305

Parent Item Name: EC145 Cable Cutter System Removable Provisions U Channel Compatible

Start Date: 3/05/15

Required Date: 3/06/15

Start Qty: 1.00

Required Qty: 1.00

AN3-11A Purchased No

Each 479.0000

AN3-11A

Bolt

DAS
46
9-89

[Handwritten mark]

Location

ST338a

Loc Qty

479

Loc Code

[Handwritten: 12]

DAS
27
9-89

DAS
27
9-89

MAR 06 2015

AN3C10A Purchased No

Each 39.0000

AN3C10A

Bolt

DAS
46
9-89

Location

ST349

Loc Qty

39

Loc Code

[Handwritten: 12]

DAS
27
9-89

DAS
27
9-89

MAR 06 2015

MS27039-08-10 Purchased No

Each 983.0000

MS27039-08-10

Screw

DAS
46
9-89

Location

ST281

Loc Qty

983

Loc Code

[Handwritten: 4]

DAS
27
9-89

DAS
27
9-89

MAR 06 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

Thursday, March 05, 2015 4:20:41 PM

Work Order ID: 130332

130332

Parent Item: 647.1305

647 1305

Parent Item Name: EC145 Cable Cutter System Removable Provisions U Channel Compatible

Start Date: 3/05/15

Required Date: 3/06/15

Start Qty: 1.00

Required Qty: 1.00

NAS1149F0332P

Purchased

No

Each

4,301.000

(70)

DAS

27

9-89

DAS

27

9-89

NAS1149F0332P

DAS

46

9-89

Washer

MAR 06 2015

Location

Loc Qty

Loc Code

GA

222

122063

222

ST260a

2586

m128401

6

m131026

80

m131697

2500

st268

1493

m130325

1493

Each

4,430.000

(8)

DAS

27

9-89

DAS

27

9-89

NAS1149FN832P

Purchased

No

NAS1149FN832P

DAS

46

9-89

Washer

MAR 06 2015

Location

Loc Qty

Loc Code

ST260a

1954

125268

1954

st268

2476

125268

1569

M130388

907

Each

639.0000

(17)

DAS

27

9-89

DAS

27

9-89

MS21042-3

MS21042L3

Purchased

No

MS21042-3

DAS

46

9-89

Nut / use MS21042L3

MAR 06 2015

Location

Loc Qty

Loc Code

CA

501

M129682

501

ST305

138

M128770

38

M129541

100

M131269

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
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Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
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Offset/Setup									
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Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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***Picklist Print**

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Page 4

Work Order ID: 130332

130332

Parent Item: 647.1305

647 1305

Parent Item Name: EC145 Cable Cutter System Removable Provisions U Channel Compatible

Start Date: 3/05/15

Required Date: 3/06/15

Start Qty: 1.00

Required Qty: 1.00

MS21042-08

MS21042L08

Purchased

No

Each

26.0000

MS21042-08

USE MS21042L08

DAS

46

9-89

Location

Loc Qty

Loc Code

ST304

25

122815

25

ST306

1

123185

1

Each

3,355.000

**

4

DAS

27

9-89

DAS

06

9-89

MAR 06 2015

MS21042L4

Purchased

No

Each

MS21042L4

Locknut

DAS

46

9-89

Location

Loc Qty

Loc Code

FP001

42

m124231

42

GA

644

m127813

644

ST260a

1140

m130799

56

m131340

1084

ST305

1529

426

426

m128300

8

m128798

4

m130922

97

m131618

994

4

DAS

27

9-89

DAS

06

9-89

MAR 06 2015

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Shop Packet Print

Page 4

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
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Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
		☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge
		☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other

Picklist Print

Thursday, March 05, 2015 4:20:42 PM

Page 5

Work Order ID: 130332

130332

Parent Item: 647.1305

647 1305

Parent Item Name: EC145 Cable Cutter System Removable Provisions U Channel Compatible

Start Date: 3/05/15

Required Date: 3/06/15

Start Qty: 1.00

Required Qty: 1.00

601.2045

Purchased

No

Each

27.0000

601 2045

DAS

46

RTV (LOCTITE 598)

9-89

Location

Loc Qty

Loc Code

CCK096

8

m131142

8

cck15a

19

m131311

19

Each

71.0000

647.2010

Manufactured

No

647-2010

DAS

46

Upper Strut

9-89

Location

Loc Qty

Loc Code

CCK094

71

106783

32

91802

1

91895

32

92516

2

m123185

4

Each

36.0000

AN3-15A

Purchased

No

AN3-15A

DAS

46

Bolt

9-77

Location

Loc Qty

Loc Code

FG

10

114941

10

ST348

26

m128429

26

DAS
27
9-89
MAR 06 2015

DAS
27
9-89
MAR 06 2015

DAS
27
9-89
MAR 06 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge	☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
--	--	---	--	--

Picklist Print

Page 6

Thursday, March 05, 2015 4:20:42 PM

Work Order ID: 130332

130332

Parent Item: 647.1305

647 1305

Parent Item Name: EC145 Cable Cutter System Removable Provisions U Channel Compatible

Start Date: 3/05/15

Required Date: 3/06/15

Start Qty: 1.00

Required Qty: 1.00

647.1403

Manufactured No

Each

9.0000

1

DAS

DAS

27

06

9-89

9-89

647 1403

DAS

46

Upper Cutter Assembly, U-Channel

9-89

MAR 06 2015

LocationLoc QtyLoc Code

cck047

9

104738

1

123306

4

128326

4

91292A080

Purchased

No

Each

44.0000

20

DAS

DAS

27

06

9-89

9-89

91292A080

DAS

46

Screw

9-89

MAR 06 2015

LocationLoc QtyLoc Code

ST564

44

M127948

44

Each

46.0000

20

DAS

DAS

27

06

9-89

9-89

93625A300

Purchased

No

Each

46.0000

20

DAS

DAS

27

06

9-89

9-89

93625A300

DAS

46

Locknut

9-89

MAR 06 2015

LocationLoc QtyLoc Code

ST564

46

M127948

46

Each

88.0000

40

DAS

DAS

27

06

9-89

9-89

93475A270

Purchased

No

Each

88.0000

40

DAS

DAS

27

06

9-89

9-89

93475A270

DAS

46

Washer

9-89

MAR 06 2015

LocationLoc QtyLoc Code

ST564

88

M127948

88

Thursday, March 05, 2015 4:20:42 PM

Shop Packet Print

Page 6

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
		☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge
		☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other

Picklist Print

Thursday, March 05, 2015 4:20:42 PM

Page 7

Work Order ID: 130332

130332

Parent Item: 647.1305

647 1305

Parent Item Name: EC145 Cable Cutter System Removable Provisions U Channel Compatible

Start Date: 3/05/15

Required Date: 3/06/15

Start Qty: 1.00

Required Qty: 1.00

LN9037-08018

Purchased

No

Each

18.0000

8

LN9037-08018

DAS
46

**

DAS

DAS

Screw

9-89

27

86

Location

Loc Qty

Loc Code

ST556

18

8

MAR 06 2015

M126230

9

M128007

9

LN9025-0820K

Purchased

No

Each

88.0000

8

LN9025-0820K

DAS
46

**

DAS

DAS

Lock Tab Washer

9-89

27

86

Location

Loc Qty

Loc Code

ST556

88

8

MAR 06 2015

M126230

28

M128007

60

647.2113

Manufactured

No

Each

5.0000

1

647-2113

DAS
46

**

DAS

DAS

Lower Rail, U-Channel

9-89

27

86

Location

Loc Qty

Loc Code

CCK108

5

1

MAR 06 2015

111624

1

123496

4

647.1702

Manufactured

No

Each

2.0000

2

647-1702

DAS
46

**

DAS

DAS

Skid Deflector Assembly

9-89

27

86

Location

Loc Qty

Loc Code

CCK043

2

2

MAR 06 2015

123368

2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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REFERENCE ONLY

DAS
46
9-89

MAR 06 2015

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APICAL INDUSTRIES ANY REPRODUCTION IN PART OR WHOLE WITHOUT
THE WRITTEN PERMISSION OF APICAL INDUSTRIES IS PROHIBITED.

NOTES: UNLESS OTHERWISE SPECIFIED

- 1 AFTER INSTALLATION, APPLY F/N 73 A/R
TO FILL GAPS AND FILLET EDGES
2. APPLY F/N 74 TO FAYING SURFACES
- 3 AT CUSTOMERS OPTION, INSTALL F/N 77
BY MATCH DRILLING ONTO F/N 1
- 4 INSTALL FOR 647.1301, 647.1302.
- 5 INSTALL FOR 647.1304, 647.1305.
- 6 APPLICABLE WHEN EUROCOPTER P/N
145-250014.11 IS INSTALLED WITH
EUROCOPTER CABLE CUTTER FIXED
PROVISIONS.
- 7 APPLICABLE WHEN REPLACING EUROCOPTER
P/N 145-250074.11

UNINCORPORATED ECN(s)

04485, 04592

REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED
LAST PROTOTYPE REVISION: P83			
N/C	INITIAL RELEASE	06/03/09	P. BRAVO
A	INCORPORATED ECN 02943, 03020, 03048	01/25/11	P. BRAVO
B	INCORPORATED ECN 03119	07/05/13	P. BRAVO
C	INCORPORATED ECN 04059	06/13/15	P. BRAVO

13		13	13		13	26	647.1812	SHIM		
4		4	4		4	25	647.1910	CLIP		
1		1	1		1	24	647.1810	NOSE DOOR DOUBLER		
1		1	1		1	23	647.1818	NOSE DOOR SPACER		
2		2	2		2	22	647.1813	ANGLE		
1		1	1		1	21	647.1913	TEE		
1		1	1		1	20	647.1814	GUSSET, LH		
1		1	1		1	19	647.1815	GUSSET, RH		
1		1	1		1	18	647.1915	SUPPORT ANGLE		
	2	2		2	2	17	647.2011	LOWER STRUT		
1		1	1		1	16	647.1914	BRACKET		
1		1	1		1	15	647.1816	SUPPORT, LH		
1		1	1		1	14	647.1817	SUPPORT, RH		
1		1	1		1	13	647.1912	BRACKET, LH		
1		1	1		1	12	647.1911	BRACKET, RH		
4		4	4		4	11	647.0112	STRUT BRACKET		
				1	1	10	647.2110	LOWER RAIL		
				1	1	9	647.2111	UPPER RAIL		
1		1	1		1	8	647.1610	WIPER DEFLECTOR, FWD		
1		1	1		1	7	647.1601	WIPER DEFLECTOR ASSY, AFT		
				2	2	6	647.1701	SKID DEFLECTOR ASSY		
1		1	1		1	5	647.3201	GROUNDING CABLE ASSY		
1		1	1		1	4	647.2201	CROSS ASSY		
1		1	1		1	3	647.1602	DOUBLER ASSY		
				1	1	2	647.1402	CUTTER ASSY (LOWER)		
				1	1	1	647.1401	CUTTER ASSY (UPPER)		
							647.1306	FIXED PROVISIONS KIT U CHANNEL		
							647.1305	REMOVABLE PROVISIONS KIT U CHANNEL		
							647.1304	EC145 CABLE CUTTERS KIT U CHANNEL COMPATIBLE		
							647.1303	FIXED PROVISIONS KIT		
							647.1302	REMOVABLE PROVISIONS KIT		
							647.1301	EC145 CABLE CUTTERS KIT		
.1306	.1305	.1304	.1303	.1302	.1301	FIND #	PART #	DESCRIPTION	MAT'L	SPEC.

BOM Table (Restructured)

QTY

NEXT ASSY (S)

ORIGINAL DATE
DRAWN BY
R. ROSANO
D. BARKER
DRAWING APPROVAL
P. BRAVO
CONTRACT NO.

PARTS LIST

APICAL INDUSTRIES
2608 TEMPLE HEIGHTS DR.
OCEANSIDE, CA. 92056-3512 (760)724-5300

EC145 CABLE CUTTERS KIT

SCALE CODE DWG. NO. 647.1300
8 07M26
SCALE NONE SHEET 1 OF 9

REFERENCE ONLY

DAS
46
9-89

MAR 06 2015

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	2	2				85	647.1702	SKID DEFLECTOR ASSY		
	1	1				84	647.2113	LOWER RAIL (U CHANNEL KIT)		
	8	8				83	601.3655	WASHER	LN9025-0820K	
	8	8				82	601.3654	SCREW	LN9037-8018	
	1	1				81	647.2112	UPPER U CHANNEL		
	4	4				80	601.3653	WASHER	93475A270	
	2	2				79	601.3652	LOCKNUT	93625A300	
	2	2				78	601.3651	SCREW	91292A080	
	1	1				77	647.1403	CUTTER ASSY (UPPER U CHANNEL)		
	5	5				76	601.3650	BOLT	AN3-15A	
REF			REF		REF	75	647.5701	GPS MOUNT KIT		
2	2	2		2	2	74	601.1954	SCREW	MS27039-1-17	
2	2		2	2	73	647.2010	UPPER STRUT			
1	1		1	1	72	601.2045	RTV	LOCTITE 598		
1	1	1		1	71	600.1012	SEALANT	PR-1425 CLASS B		
1	1	1		1	70	600.0991	MAGNOBOND 6398 PART B			
1	1	1		1	69	600.0990	MAGNOBOND 6398 PART A			
4	4	4		4	68	601.3012	SCREW	MS27039-1-15		
2	2	2		2	67	601.3004	CAMLOC STUD			
2	2	2		2	66	601.3005	CAMLOC RETAINER			
2	2	2		2	65	601.3006	CAMLOC RECEPTACLE			
3 FT.	3 FT.	3 FT.		3 FT.	64	601.3011	P-SEAL			
1.1 FT.	1.1 FT.	1.1 FT.		1.1 FT.	63	601.3007	GROMMET	MS21266-2N		
2	2	2		2	62	601.3008	INSERT	NAS1834C-300		
11	11	11		11	61	601.2991	RIVET	CR3213-4-6		
2	2	2		2	60	601.1039	RIVET	CR3213-4-2		
8	8	8		8	59	601.1183	RIVET	CR3213-4-5		
.1306	.1305	.1304	.1303	.1302	.1301	FIND #	PART #	DESCRIPTION	MATL	SPEC.

BOM Table(Restructured)

22		22	22		22	58	601.0790	RIVET		CR3213-4-3	
8		8	8		8	57	601.2995	RIVET		CR3213-6-6	
4		4	4		32	56	601.1915	RIVET		CR3213-4-4	
12		12	12		12	55	601.2207	NUTPLATE RIVET		CCR2645S-3-03	
4		4	4		4	54	601.1983	NUTPLATE RIVET		CCR2745S-3-03	
12		12	12		12	53	601.2980	NUTPLATE RIVET		CCR2645S-3-04	
12		12	12		12	52	600.0795	NUTPLATE		MS21047-3	
	4	4		4	4	51	601.3209	LOCKNUT		MS21042L4	
5	4	9	5	4	9	50	601.2973	LOCKNUT		MS21042-08	
29	17	46	29	16	45	49	601.2943	LOCKNUT		MS21042-3	
3		3	3		3	48	601.2375	WASHER			
10	8	18	10	8	18	47	601.2764	WASHER		NAS1149FN832P	
	70	32	70	32	102	46	601.1607	WASHER		NAS1149F0332P	
1		1	1		1	45	601.2525	SCREW		MS27039-0807	
4		4	4		4	44	601.1952	SCREW		MS27039-1-20	
	4	4		4	4	43	601.3010	SCREW		MS27039-0810	
4		4	4		4	42	601.3224	SCREW		ANS25-10R12	
6		6	6		6	41	601.1365	SCREW		MS27039-1-10	
3		3	3		3	40	601.2198	SCREW		MS27039-1-07	
3		3	3		3	39	601.2999	SCREW			
18		18	18		18	38	601.2459	SCREW		MS27039C1-06	
4		4	4		4	37	601.1622	SCREW		MS27039-1-14	
10		10	10		10	36	601.2051	SCREW		MS24694C52	
2		2	2		2	35	601.2823	BOLT		AN3-4A	
1		1	1		1	34	601.1324	BOLT		AN4CH6A	
	2	2		2	2	33	601.1874	BOLT		AN3CT0A	
	12	12		16	16	32	601.2826	BOLT		AN3-11A	
8		8	8		8	31	601.2638	WASHER		NAS1149F0432P	
4		4	4		4	30	601.3002	BOLT		NAS6604-66	
2		2	2		2	29	647.1811	SPACER			
4		4	4		4	28	647.2511	NUT			
4		4	4		4	27	647.2510	SLEEVE			
.1306	.1305	.1304	.1303	.1302	.1301	FIND #	PART #	DESCRIPTION	MATL	SPEC.	

BOM Table(Restructured)

ORIGINAL DATE 02-01-06
DRAWN BY D. BARBER
R. ROSANO
DRAWING APPROVAL P. BRAVO 06/03/09
CONTRACT NO.

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
TOLERANCES ARE:
2 PLACE DECIMALS ±.03
3 PLACE DECIMALS ±.010
ANGLES ±.3°

APICAL INDUSTRIES
2608 TEMPLE HEIGHTS DR.
OCEANSIDE, CA. 92056-3512 (760)724-5300

EC145 CABLE CUTTERS KIT

SIZE B CAGE CODE 07M26 DWG. NO. 647.1300 REV. C
SCALE NONE SHEET 2 OF 9

APICAL
INDUSTRIES, INC.

ENGINEERING CHANGE NOTICE NO. 04592

SHEET 1 OF 1

DWG NO. 647.1300

REV: C

PREPARED BY:

J. BECKER

DATE: 06/19/14

EFFECT ON DWG
☐ INC. ☒ UNINC.

DWG TITLE: EC145 CABLE CUTTERS KIT

APPROVED BY:

ENGR

MFG

QC

EFF:

CURRENT STOCK

TRANSACTION CODES (TC):
A-ADD C-CREATE
R-REVISE D-DELETE

REASON: REVISED BOM.

REFERENCE ONLY
MAR 06 2015

DAS
46
9-89

ACTION LIST:

1. ADD F/N 11 TO ALL CURRENT KITS IN STOCK

2. UPDATE III145-2 & ICA145-2

11	R	647.0112	81	8			STRUT BRACKET		
F/N	TC	PART NUMBER	.1306	.1305	.1304	.1303	DESCRIPTION	MATERIAL	SPECIFICATION
DOCUMENTS EFFECTED:			☐ MDL ☒ INSTALL INSTRU ☒ ICA ☒ BOM				CHANGE CATEGORY	DER REVIEW REQUIRED	
							☐ MAJOR ☒ MINOR	☐ YES ☒ NO	